## WHAT IS CLAIMED IS:

1		1.	A	method	of	producin	g	composite	vehicle	door	panels
2	comprising:										
3	manufacturing a skin in a vacuum-forming mold;										
4	transferring the skin to a RIM mold;										
5		applyi	ing 1	natural fi	iber	and an is	осу	anate and	resin mi	xture o	onto the
6	skin;										
7		polymerizing the isocyanate and resin mixture, natural fiber, and a									
8	skin into a composite vehicle door panel.										
1		2.	Th	e metho	d of	claim 1 v	vhe	erein the n	atural fib	ers are	hemp,
2	kenaf, sisal, flax, or jute.										
1		3.	Th	e metho	od c	of claim	1	further co	mprising	the	step of
2	trimming the skin before natural fibers are placed on the skin.										
1		4.						further co	-		-
2		ng the skin after the isocyanate and resin mixture, natural fiber, and the skin									
3	have polymer	nzed.									
1		5.	Th	e metho	d of	claim 1 w	hei	rein the nat	ural fibor	c are n	rovided
2	as rovings.	٥.	11.	ic memor	101	Claim I w	пс	chi me na	urai moci	s are p	TOVIGCG
-	as rovings.										
1		6.	Th	e method	l of o	claim 1 w	her	ein the nat	ural fiber	s are p	rovided
2	as a mat.										
1		7.	Th	e metho	od o	f claim	1	wherein t	he natur	al fibe	ers and
2	isocyanate and resin mixture are applied to the skin simultaneously.										
1		8.	Th	e metho	d of	claim 1 w	he	rein the na	ıtural fibe	ers are	applied
2	to the skin fir	rst and	the	isocyana	te ai	nd resin r	nix	ture are a	pplied or	to the	natural
3	fibers.										